

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015278**Date Inspected:** 28-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

West of Bay 14-

Caltrans QA Inspector observed the following work in progress: Shielded Metal Arc Welding (SMAW) of OBG Segment 12AW external manway stiffener welds, SEG3004-179 and 180. ZPMC welders were identified as 069683 and 047864. ZPMC QC was identified as Tang Ya Jun. ZPMC CWI was identified as Li Yan Hua. The welding appeared to be in conformance with welding procedure specification, WPS-B-P-2114-FCM-1.

Shielded Metal Arc Welding (SMAW) of OBG Segment 11BW side panel web stiffener welds, SP742-001-300~303. ZPMC welders were identified as 201087 and 204339. ZPMC QC was identified as Tang Ya Jun. ZPMC CWI was identified as Li Yan Hua. The welding appeared to be in conformance with welding procedure specifications, WPS-B-P-2114-FCM-1 and WPS-B-P-2111-FCM-1.

Caltrans QA observed ABF QC performing Ultrasonic Testing of deck panel to edge plate corner weld joint from panel point 104 to 106 on the cross beam side.

West of Blast Bay 1-

Shielded Metal Arc Welding (SMAW) of OBG Segment 12CE FL1 Flange welds, SEG3003H-136 and 137.

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## WELDING INSPECTION REPORT

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ZPMC welder was identified as 049339. ZPMC QC was identified as Wang Wei Ming. ZPMC CWI was identified as Li Yan Hua. The welding appeared to be in conformance with welding procedure specifications, WPS-B-P-2212-B-U2-FCM-1.

Blast Bay 1-

Caltrans QA Paint Inspector James Lumley requested that base metal damage areas be evaluated mapped and placed on the punchlist for repair at a future date by Caltrans Certified Welding Inspector. Upon arrival ABF QC Don Walton stopped ZPMC and ABF Visual inspection. Removed all ZPMC grinding personnel, ABF and ZPMC QC and redirected ZPMC to resume blasting, denying access to Caltrans QA to evaluate the base metal damage observed by Mr. Lumley.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

As identified within the contents of this report.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

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| <b>Inspected By:</b> | Viars,Larry       | Quality Assurance Inspector |
| <b>Reviewed By:</b>  | McClendon,Timothy | QA Reviewer                 |

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